

SPLIT - 2

Work Order ID 119351

119351

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Thursday, May 15, 2014 3:41:46 PM

Item ID: D4952-041 Accept *N9000040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Wearplate Assembly
 Start Date: 5/15/14 Start Qty: 14.00 *14* Cust Item ID:
 Required Date: 5/15/14 Req'd Qty: 14.00 *14* Customer:
 Reference:

Approvals: Process Plan: MLS Date: 4-05-21 Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D4952	A								

110

0.00

110

Large Fab

Large Fab

Memo

0.00

Large Fab

1- PICK D4952-1 AND D4379-3

2- Weld hardcoat and cups as per dwg using DT10002

2059B hardcoat batch: M129649

304/316 S.S. ROD batch: M125054

120

QC9- Inspect visual per QSI004- Fusion Welds

0.00

120

QC

Memo

0.00

Quality Control

16 14-09-17 MAL

16 SEP 17 2014

DAS
24
9-89

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Revision ID: Stop ***NS2***

Item Name: Wearplate Assembly

Start Date: 5/15/14 Start Qty: 14.00

14

Cust Item ID:

Required Date: 5/15/14 Req'd Qty: 14.00

14

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start ***NR1***

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 *130* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00				16	SEP 17 2014		DAS 24 9-89
140 *140* Packaging Packaging	Identify as per dwg & Stock Location: 5467 Memo	0.00 0.00				16	7/14/15		
150 *150* QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00				MJS	1409-19		MF 14-9-19

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D4952-041

Start Date: 5/15/14

Required Date: 5/15/14

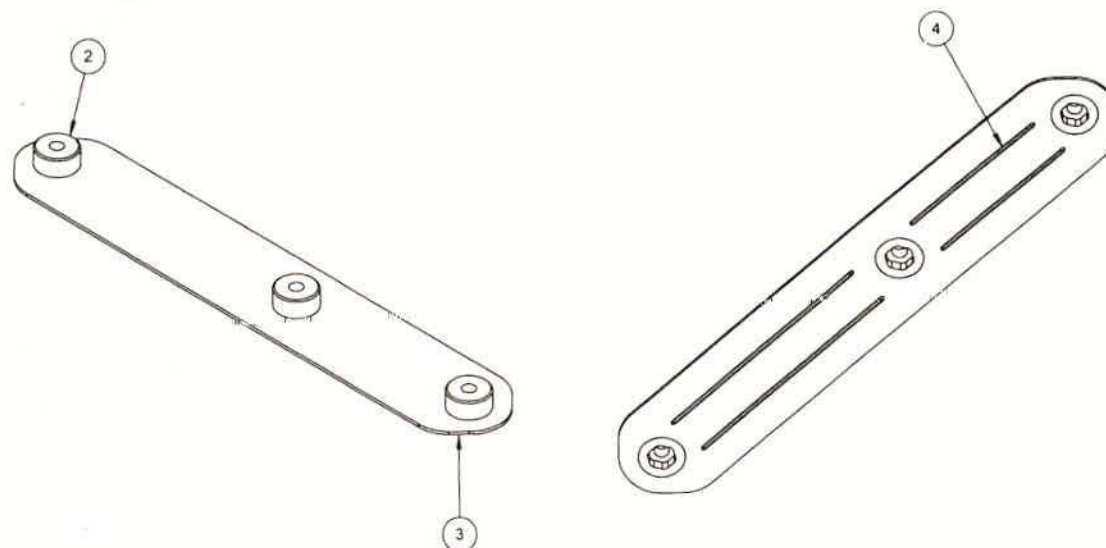
Start Qty: 14.00

Required Qty: 14.00

Comments: IPP REV:A 13.09.30 NEW ISSUE DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4379-3		Manufactured	No				Each	107.0000		42			
<p>*D4379-3*</p> <p>Wearplate Cup</p> <p>B121143 x 34 B121143 x 14</p> <p>B121143 x 34 B119018 x 34</p> <p>B121143 x 34 WA002</p> <p>111636</p> <p>119018</p> <p>107</p> <p>56</p> <p>51</p> <p>**</p> <p>848</p> <p>14-09-17 MAL</p>													
D4952-1		Manufactured	No				Each	0.0000		14			
<p>*D4952-1*</p> <p>Wearplate</p> <p>B114319 x 16</p> <p>**</p> <p>x16</p> <p>14-09-17 MAL</p>													

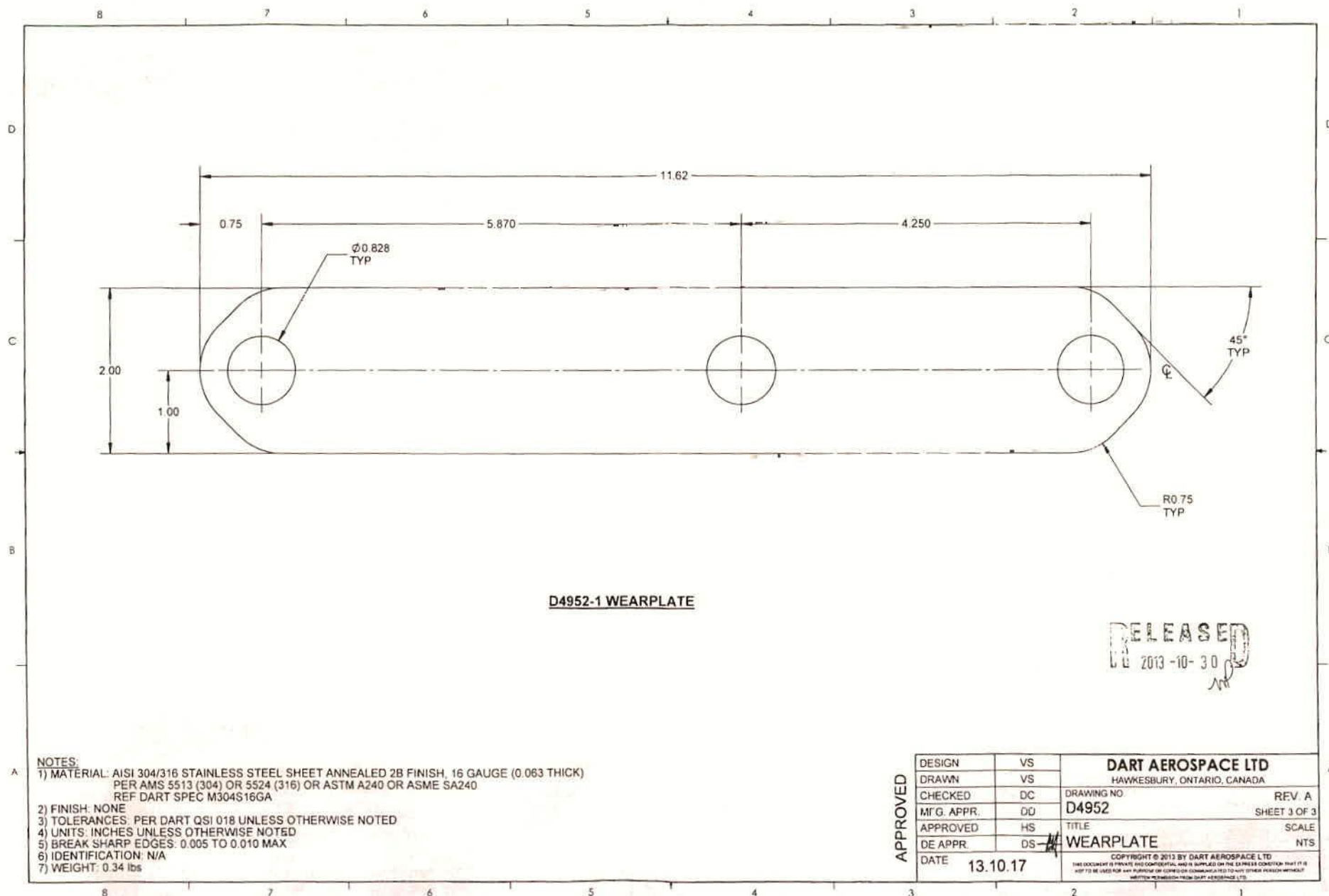
ITEM	QTY -041	P/N	DESCRIPTION
1	X	D4952-041	WEARPLATE ASSEMBLY
2	3	D4379-3	WEARPLATE CUP
3	1	D4952-1	WEARPLATE
4	A/R	2059B	HARDCOAT



D4952-041 WEARPLATE ASSEMBLY

A	NEW ISSUE	VS	13.09.23
REV.	DESCRIPTION	BY	DATE
DESIGN	VS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	VS		
CHECKED	DC	DRAWING NO.	REV. A
MFG. APPR.	DD	D4952	SHEET 1 OF 3
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	WEARPLATE	NTS
DATE	13.10.17	<small>COPYRIGHT © 2013 BY DART AEROSPACE LTD THIS DOCUMENT IS UNCLASSIFIED AND IS SUPPLIED ON THE UNDERSTANDING THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD</small>	

APPROVED



NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET ANNEALED 2B FINISH, 16 GAUGE (0.063 THICK)
PER AMS 5513 (304) OR 5524 (316) OR ASTM A240 OR ASME SA240
REF DART SPEC M304S16GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.34 lbs

APPROVED

DESIGN	VS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	VS		
CHECKED	DC	DRAWING NO	REV. A
MFG. APPR.	DD	D4952	SHEET 3 OF 3
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	WEARPLATE	NTS
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